

Date: Thursday, 26/10/2006 1:16:57 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET
Job Number	: 29040		
Estimate Number	: 11692		
P.O. Number	: <u>N/A</u>	Part Number	: D2705
This Issue	: 26/10/2006 S.O. No. : <u>N/A</u>	Drawing Number	: D2705 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 29040	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 30/10/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. B 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:C Now On Waterjet JLM 06-10-24		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0437 sf(s)/Unit Total : 0.4368 sf(s)

6061-T6 .063 Sheet

Material: 6061-T6 or 5052 H32 or 2024-T3 0.063" thick

Batch: 111932E

ml 06 12 01

m18556

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2705

Dwg Rev: AProg Rev: A

ml 06 12 01

(10)

2-Deburr if necessary

ml 06/12/01

SAP 06-11-04

(10)

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 06 12 01



10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 06-11-04

(10)

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/12/01 (10)

Date: Thursday, 26/10/2006 1:16:57 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 29040

Part Number: D2705

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend on brake as per Dwg D2705

SB

06/12/05

(10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/06 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M102391

yl

06/12/13 X 10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/12/15 (5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5157

06/12/15 (5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/15 (5)

Job Completion

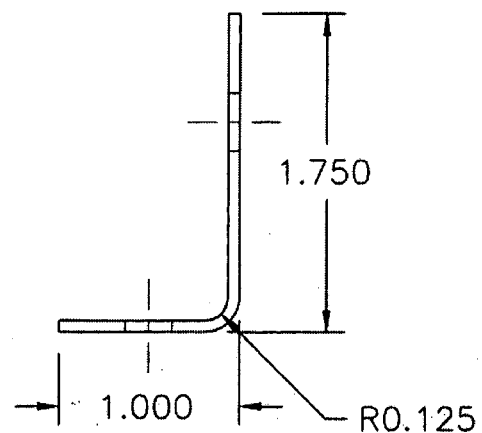
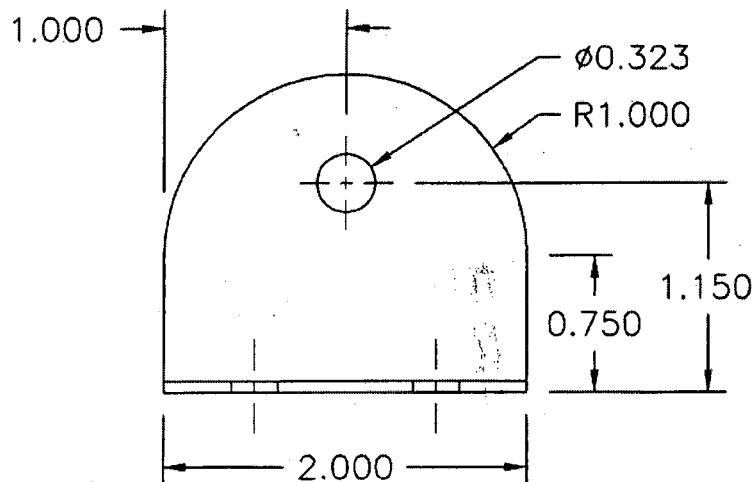
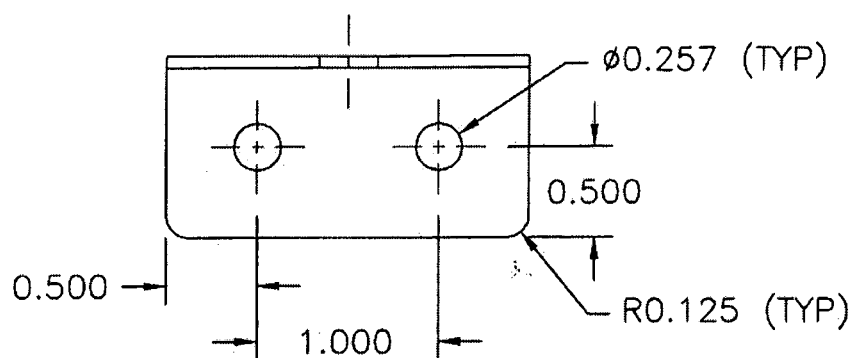


06/12/15



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>my</i>	APPROVED <i>KE</i>	DRAWING NO. D2705	REV. A SHEET 1 OF 1
DATE 97.10.10		TITLE SUPPORT BRACKET	SCALE 1:1
A	97.10.10	NEW ISSUE	

RELEASED
471023 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29040

MATERIAL: 5052-H32 (QQ-A-250/8) OR 2024-T3 (QQ-A-250/4)
OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/06	3	All parts scrap due to grain direction	<i>EC</i>	destroy parts and redo on water jet. (check grain direction)	M.F. 06/11/06	<i>DL</i> 06/11/06		<i>EC</i>

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:19:59 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT BRACKET
Job Number : 29040
Estimate Number : 11692
P.O. Number : Part Number : D2705
This Issue : 10/17/2006 S.O. No. : Drawing Number : D2705 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : // Type : SMALL /MED FAB Drawing Revision : A
Previous Run : Material :
Written By : Due Date : 10/30/2006 Qty: 10 Um: Each
Checked & Approved By : 061017
Comment : Est. B 00.11.01 Removed P/O for Powder Coat - in house
processEC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0437 sf(s)/Unit Total : 0.4368 sf(s)

6061-T6 .063 Sheet

Material: 6061-T6 or 5052 H32 or 2024-T3 0.063" thick

Batch: _____

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut blanks: 2.000" x 2.650"

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill holes as per Dwg D2705 using Drill Jig DT8252

Grind radius as per Dwg D2705

4.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Bend on brake as per Dwg D2705

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP